

Work Order ID 129156

January-29-15 2:48:20 PM

129156

OK

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D3152-042 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket Assembly
 Start Date: 1/29/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 2/06/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3152	REV C.

100	Small Fab	0.00							
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100

Small Fab

Small Fab

Memo

Bond D3152-4 Seal to D3152-2 Bracket using RTV 732 per Dwg D3152.

RTV 732 Black Batch: M131036

Expiry: 12-16-16

Identify as D3152-041

110	QC5- Inspect part completeness to step on W/O	0.00							
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110

QC

Quality Control

Memo

0.00

DAS
38
9-89

FEB 26 2015

DAS
36
9-89

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Page 2

Item ID: D3152-042 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket Assembly
Start Date: 1/29/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/06/15 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>frederick</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

1532

POSITIVE RECALL
EFFECTIVE 1/29/15 AUTH h
RELEASED _____ DATE _____

Picklist Print

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Page 1

Work Order ID: 129156

129156

Parent Item: D3152-042

D3152-042

Parent Item Name: Bracket Assembly

Start Date: 1/29/15

Required Date: 2/06/15

Start Qty: 1.00

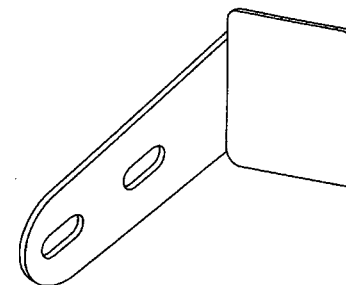
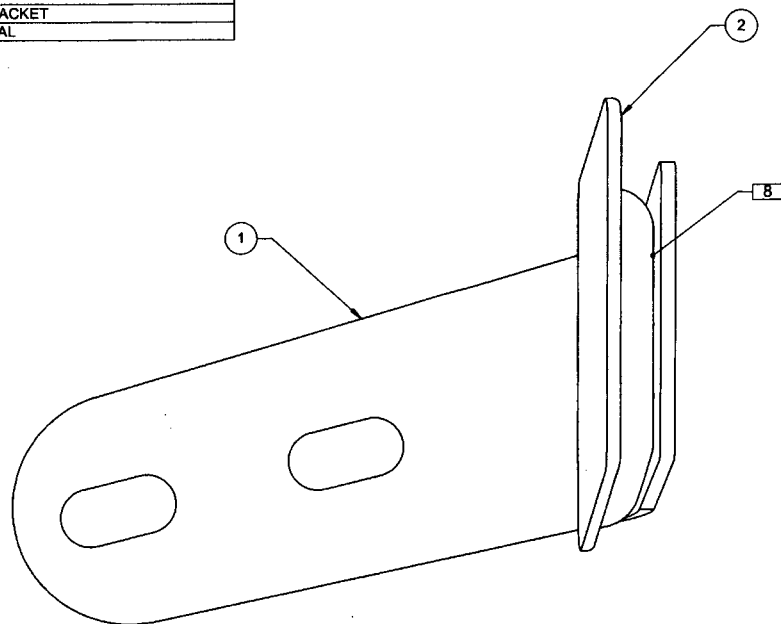
Required Qty: 1.00

Comments: IPP Rev:B Removed Purchasing 05-12-19 JLM IPP REV:C
15.01.29 SEAL NOW MADE IN HOUSE DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3152-2 *D3152-2* Bracket		Manufactured	No			100	Each	0.0000	1	1		DAS 30 9-89	15/02/26
D3152-4 *D3152-4* Seal		Manufactured	No			100	Each	0.0000	1	1		DAS 30 9-89	15/02/26

~~POSITIVE RECALL
EFFECTIVE _____ AUTH _____
RELEASED _____ DATE _____~~

ITEM	QTY	P/N	DESCRIPTION
	X	D3152-041	BRACKET ASSY
1	1	D3152-1	BRACKET
2	1	D3152-3	SEAL



D3152-041 BRACKET ASSEMBLY

RELEASED

2015 FEB 13

ECN 14-463 97

NOTES:

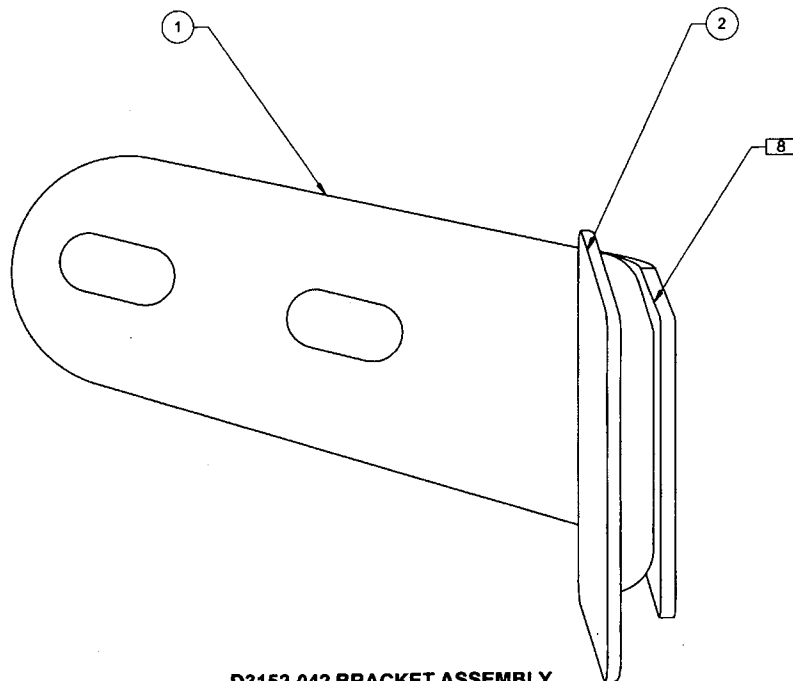
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) BOND D3152-3 SEAL TO D3152-1 BRACKET USING RTV 732 CLEAR (A/R) OR RTV 732 BLACK (A/R)

153-2
129156

APPROVED

C	REVISE D3152-3/4 (MATERIAL), RE-FORMAT DRAWING, RE-DIMENSION D3152-1F	DB	14.10.28
B	ADD PART MARKING & RTV 732 BLACK	RF	04.10.18
A	NEW ISSUE	HS	02.04.24
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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ITEM	QTY -042	P/N	DESCRIPTION
	X	D3152-042	BRACKET ASSY
1	1	D3152-2	BRACKET
2	1	D3152-4	SEAL



D3152-042 BRACKET ASSEMBLY

RELEASED

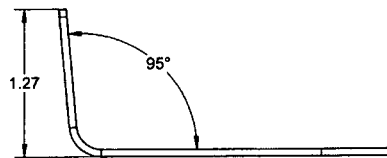
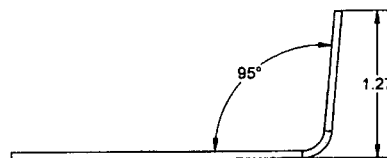
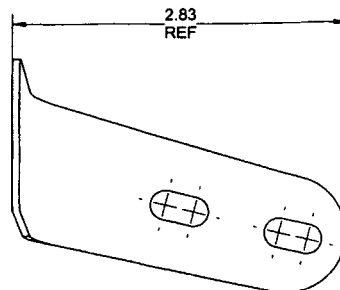
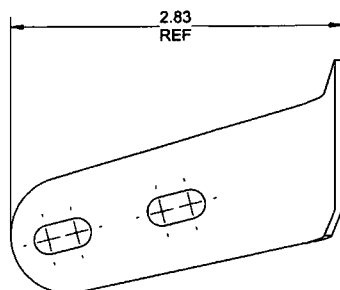
2015 FEB 13 *47*

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs
- 8) BOND D3152-4 SEAL TO D3152-2 BRACKET USING RTV 732 CLEAR (A/R) OR RTV 732 BLACK (A/R)

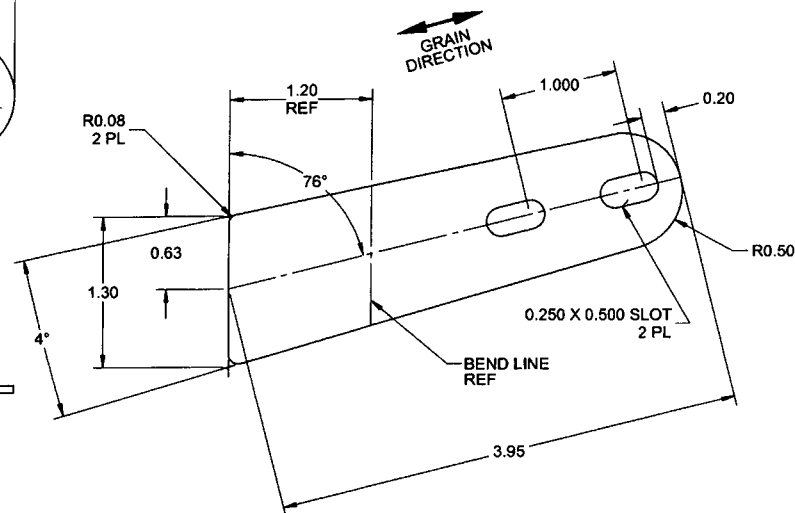
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DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO. D3152	REV. C SHEET 2 OF 5
MFG. APPR.	JLM	TITLE BRACKET ASSEMBLY	SCALE NTS
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DE APPR.	DS-#		
DATE	14.10.28		



D3152-1 BRACKET
(MAKE FROM D3152-1F)
(REPLACES PREMIER P/N B30-23000-223)

D3152-2 BRACKET
(MAKE FROM D3152-1F)
(REPLACES PREMIER P/N B30-23000-224)



D3152-1F BRACKET
(FLAT PATTERN)

RELEASED

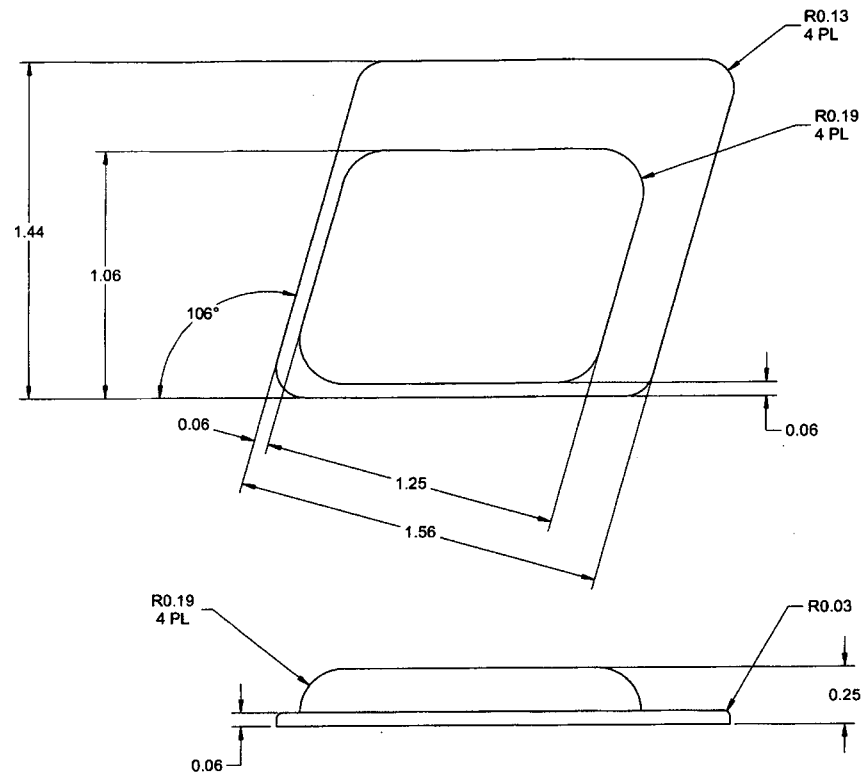
2015 FEB 13

NOTES:

- 1) MATERIAL: D3152-1F: 2024-T3 ALUMINIUM SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 PER DART SPEC M2024T3S.063
- 2) FINISH: D3152-1/-2: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

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DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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D3152-3 SEAL
(REPLACES PREMIER P/N B30-23000-243)

RELEASED

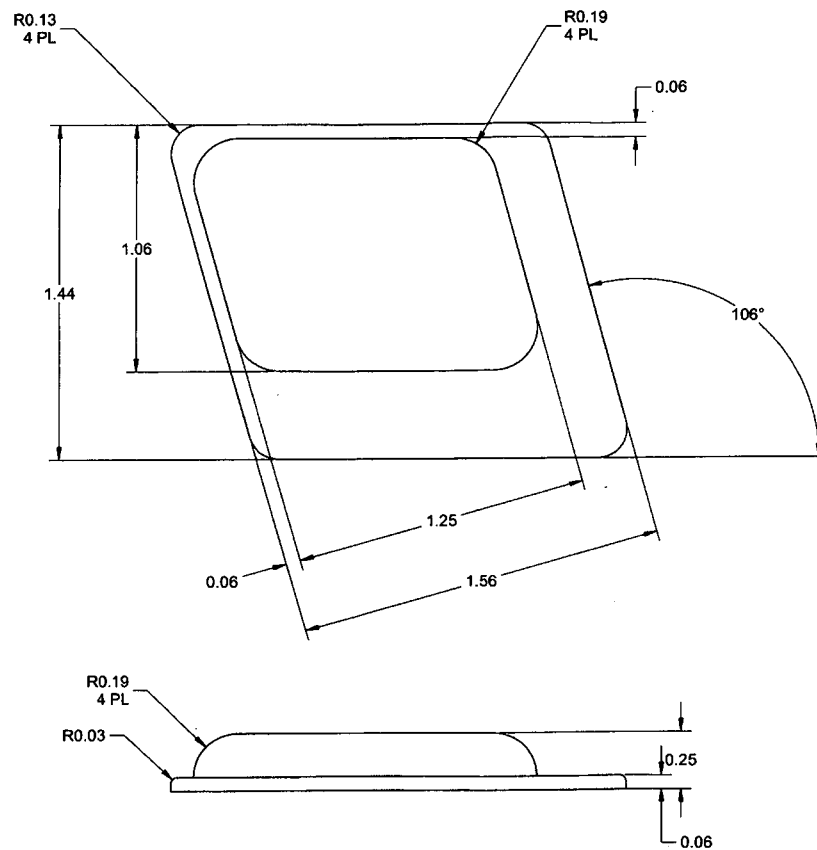
2015 FEB 13

NOTES:

- 1) MATERIAL: M-SILCC-65A (2 PART SILICONE CASTING RESIN, SHORE 65A)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.02 lbs
- 8) MAKE PARTS USING TOOL # DT10106 AND QSI 006 SECTION 4.18

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 4 OF 5
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D3152-4 SEAL
(REPLACES PREMIER P/N B30-23000-244)

RELEASED

2015 FEB 13 *q*

NOTES:

- 1) MATERIAL: M-SILCC-65A (2 PART SILICONE CASTING RESIN, SHORE 65A)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.02 lbs
- 8) MAKE PARTS USING TOOL # DT10106 AND QSI 006 SECTION 4.18

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D3152	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BRACKET ASSEMBLY	NTS
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